

Date:
User:Wednesday, 06/08/2008 10:51:21 AM
Valerie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 41013 - 2
 Estimate Number : 13524
 P.O. Number :
 This Issue : 06/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : mf 08-08-06
 Comment : Est Rev:A 08-07-25 new issue DD verified by:ec



Drawing Name : LONGITUDINAL SUPPORT ASSEMBLY
 Part Number : PB674300145
 Drawing Number : B6743001 P.13
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 13/08/2008 Qty: 5 Um: Each

Additional Product

Job Number:



was alone

Seq. #:	Machine Or Operation:	Description :
1.0	240107	SPRING SLOTTED PIN
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) SPRING SLOTTED PIN batch: <u>M11850</u>	
2.0	PB674300197 <u>840015</u>	Clevis
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Clevis batch: <u>840015</u>	
3.0	PB6743001357 <u>841012</u>	Tube Arm
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Tube Arm batch: <u>841012</u>	
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1- line drill -97 and -357 using existing pilot hole of -357 as per dwg 2- install spring pin	
5.0	QC5	INSPECT WORK TO CURRENT STEP
		
	Comment: INSPECT WORK TO CURRENT STEP <u>08/09/26 (+5)</u> <u>08/08/13 (+3)</u>	

1912

1912

1912

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



~~M102316~~

M102316



3X
5X

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

~~1:15~~
~~320~~
~~1:45~~

9:20
320°F
~~1:15~~

mk 08/09/27
08/08/13

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



~~HA~~

08/09/29



3X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D34475

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Clevis

batch:

~~39967~~ 344221

pk 08-09-29

5

9.0

D34471

Round Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Round Spacer

batch:

~~41171~~ 341179

pk 08-09-29

5

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

batch:

~~09959~~ M109282

pk 08-09-29

5

11.0

NAS1149F0432P

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

batch:

~~18057~~ M18057

pk 08-09-29

5

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Nut

batch:

~~108180~~ M108145

pk 08-09-29

5

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13.0

MS17984C410

QUICK PIN REPLACEMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

QUICK PIN REPLACEMENT

batch: ~~18118~~ M18118

08.09.29 5
~~08.08.26 3~~

14.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

LANYARD

batch: ~~17828~~ M17828

08.09.29 5
~~08.08.26 3~~

15.0

BSP43

RIVET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

RIVET

batch: ~~7890~~ M109119

08.09.29 5
~~08.08.26 3~~

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Washer

batch: ~~6085~~ M6085

08.09.29 5
~~08.08.26 3~~

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble parts as per dwg PB67-43001

08.09.29 5
~~08.08.26 3~~

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Solo/30 (45)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 513

08/09/30 (x5)

1000
1000
1000
1000
1000

1000
1000
1000
1000
1000

1000
1000
1000
1000
1000

1000

1000

1000

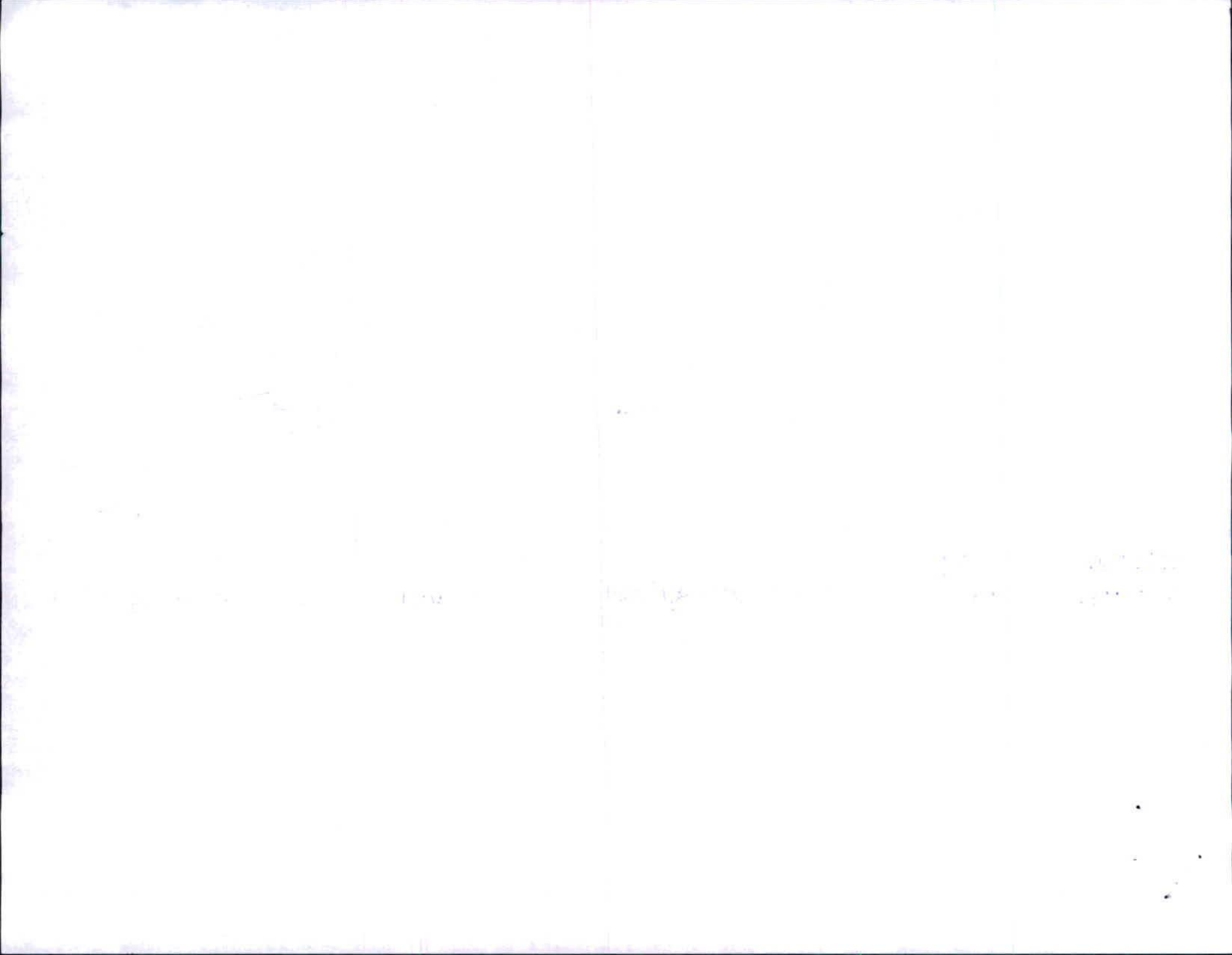
1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-345 PAR #: N/A Fault Category: Prod / Insp. Mfg NCR: Yes No DQA: D Date: 08/10/03
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 08/10/03

NCR: <u>41013</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/03	K50	welder drilled hole for MS1225 ^{AS100} rivet in wrong location. RC didn't pay attention open Human error	08/09/29	fill hole with weld AS100 ^{AS100}	<i>[Signature]</i>	08/09/30	<i>[Signature]</i>	08/09/29
				Repl weld flush	<i>[Signature]</i>	08/09/30		
				Inspect QC 5	n/a	08/09/30		
				Re Reader cont AS per AS1005	m/h 08/09/30	08/09/30		
				Inspect QC 3	n/a	08-09-30 (X)		08/09/29

NOTE: Date & initial all entries



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Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/02 *MF*

Job Completion



MF 08-09-30

① -51 LONG T-HANDLE ASSEMBLY

SCALE 0/250

362°0 17W58

052 0 1700

① -57 STABILIZER ARM

 KMOHS

④




0-4000

(1) 1/2" NPT VALVE

(2) 1/2" NPT FITTING

(3) 1/2" NPT VALVE

(4) 1/2" NPT FITTING

(5) 1/2" NPT VALVE

(6) 1/2" NPT FITTING

44.80 RS F




NO 38 (6/126) TARD
LINE-101 517 PIN
LINE DRILL 93 AND 95/357
USING EXISTING PILOT HOLE

WATSON 10714
10714-10714
10714-10714

Figure 1: A schematic diagram of a two-dimensional rectangular domain. The domain is a rectangle with a horizontal bottom edge and a vertical right edge. A coordinate system is shown with the origin at the bottom-left corner. The horizontal axis is labeled 'x' and the vertical axis is labeled 'y'. The domain is divided into two regions by a vertical line at $x = 1$. The region to the left of $x = 1$ is labeled 'Region I' and the region to the right is labeled 'Region II'. The boundary at $x = 1$ is labeled 'Interface'. The boundary at $x = 0$ is labeled 'Left Boundary'. The boundary at $x = 2$ is labeled 'Right Boundary'. The boundary at $y = 0$ is labeled 'Bottom Boundary'. The boundary at $y = 1$ is labeled 'Top Boundary'. The domain is labeled 'Domain'.

104-101-001

(1) HIGH 11:00 H:00
 DAY (01 - 00)
 01:00 - 00

11054-1

100-10114-201511-201518

LINE DRIFF RS AND B7
2-0-57 P 18

7841 1921 203 25 08-

RELEASED

41013

